

# Work Order ID 60868

Monday, July 26, 2010 11:44:34 AM



Page 1

Item ID: D3564-5

Revision ID:

Item Name: Wearshoe

Start Date: 7/26/2010 Start Qty: 12.00

Required Date: 8/3/2010 Req'd Qty: 12.00

Reference:

Accept



Setup

Start

Stop

Cust Item ID:

Customer:

Run

Start

Stop

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D	0.00							
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo								
304 .063	1-Cut as per Dwg D3564 <input type="checkbox"/> Dwg Rev: <u>D</u> <input type="checkbox"/> Prog Rev: <u>D</u> <input type="checkbox"/> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
Quality Control	Memo								

MAT not pulled

1810-7-28

(13)

1810-7-28

(+13)

8/10/08/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3564-5

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Start Date: 7/26/2010 Start Qty: 12.00

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE  Memo Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 <input type="checkbox"/> Form Joggle as per Dwg D3564 on brake using Jig DT8157	0.00  0.00				(13)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Ensure joggle as per dwg D3429	0.00  0.00				(13)			
150  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 11:00 <input type="checkbox"/> OVEN TEMPERATURE: 3200 <input type="checkbox"/> FINISH TIME: 11:30	0.00  0.00				13	d		

W/O:		WORK ORDER CHANGES					
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Monday, July 26, 2010 11:44:34 AM

Page 3

Item ID: D3564-5

Accept

Revision ID:

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Required Date: 8/3/2010 Req'd Qty: 12.00

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Cust Item ID:

Customer:

Setup

Start

Stop

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location  Memo	0.00 0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

10 08 05 (13)

13 BL 10-8-5

10/08/06  
MF  
10-8-05

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 26, 2010 11:44:38 AM

Page 1

Work Order ID: 60868

Parent Item: D3564-5

Parent Item Name: Wearshoe



Start Date: 7/26/2010

Start Qty: 12.00

Required Date: 8/3/2010

Required Qty: 12.00

## Comments:

IPP Rev:A New Issue 07-03-08 ec  
 IPP Rev:B As per Rev C 07-07-09 JLM  
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC  
 IPP Rev D added DT# 08.04.21 DD Verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	37.8267	1.5	18.94737	19.5		



304/316 Sheet .063



B10-7-28

## Location

MAT

111323  
114799

## Loc Qty

37.82669474  
0  
37.8266947

## Loc Code

114799

(B)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 60865
Description: Wearshoe		Part Number: D3564-5
Inspection Dwg: D3564	Rev: D	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	*		T 1801	
6.75	+/-0.030	6.75	*		T	
10.00	+/-0.030	10.00	*		T	
20.00	+/-0.030	20.00	*		T	
30.00	+/-0.030	30.00	*		T	
2.50	+/-0.030	2.50	*		V 1802	
3.227	+/-0.010	3.224	*		V	
38.500	+/-0.010	38.500	*		T	
5.500	+/-0.010	5.500	*		T	
2.50	+/-0.030	2.50	*		V	
2.432	+/-0.010	2.439	*		V	
0.300 x 0.300	+/-0.010	303 x 303	*		V	
Ø0.188	+0.005/-0.001	1190	*		V	
R0.375	+/-0.010	375	*		RG	
0.063	+/-0.010	060	*		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-7-28	Date: 10/08/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DD

W/O:			WORK ORDER CHANGES					
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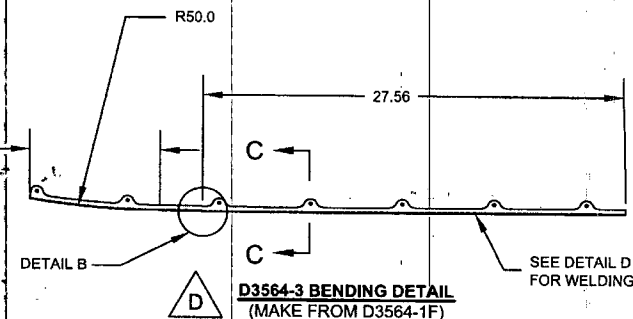
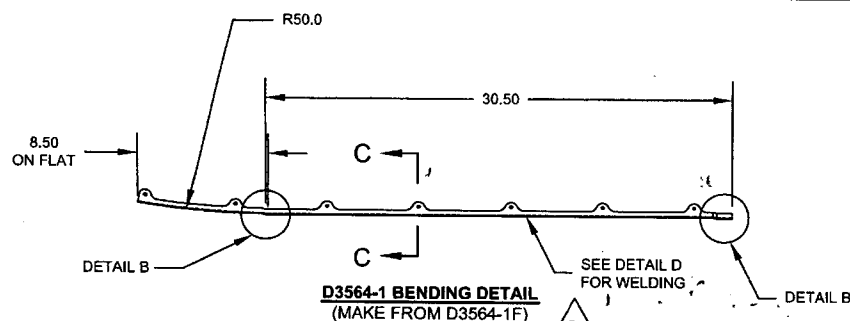
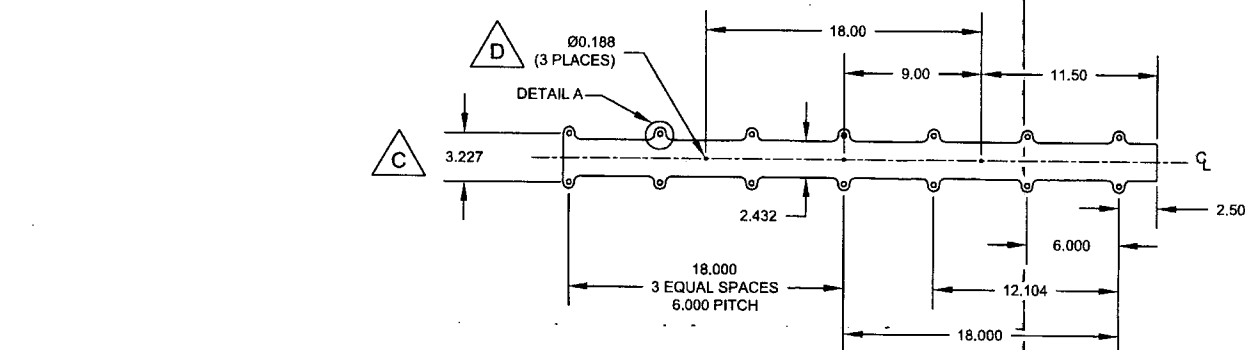
**NOTE:** Date & initial all entries

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WORK ONLY  
NO. 60868

10-7-26

RELEASED  
10.09.04

D3564-1F FLAT PATTERN



**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C-C

**WEIGHTS:**

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5.7,B2: RELOCATE DETAILS AND SECTION; PG3 A5.7,B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21	
	C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17	
	B	ADD AMS 5513 AND AMS 5524	PH	07.03.20	
	A	NEW ISSUE	PH	06.12.18	
	REV.	DESCRIPTION		BY	DATE
	DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	DRAWN	CB			
	CHECKED	PH	DRAWING NO.	REV.	1 OF 3
	MFG. APPR.	PH	D3564	SHEET 1	
APPROVED	PH	TITLE	SCALE		
DE APPR.	PH	WEARSHOE			
DATE	07.08.21		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

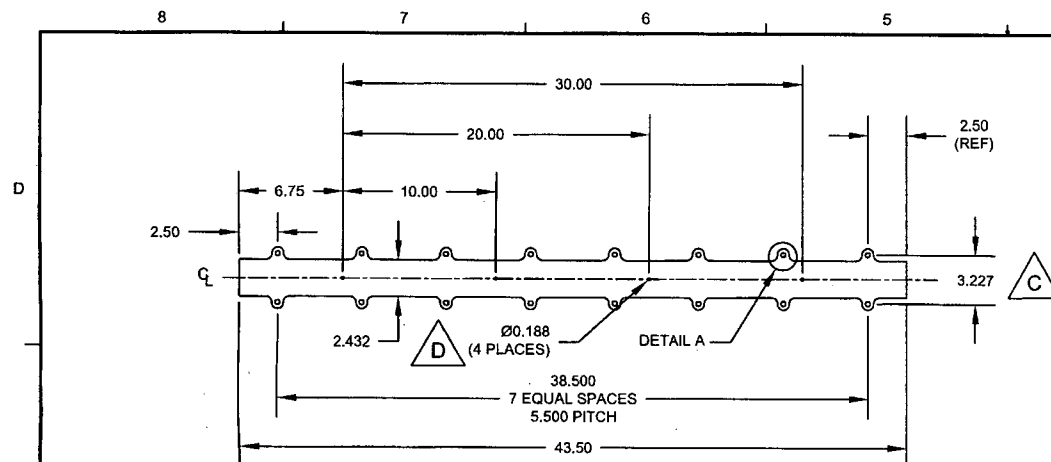
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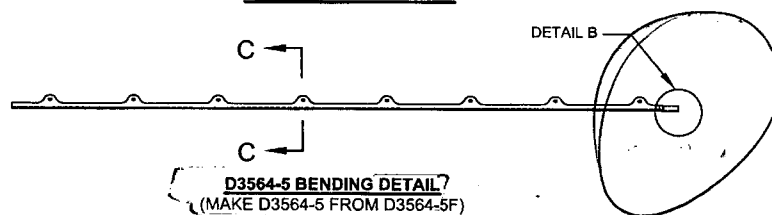
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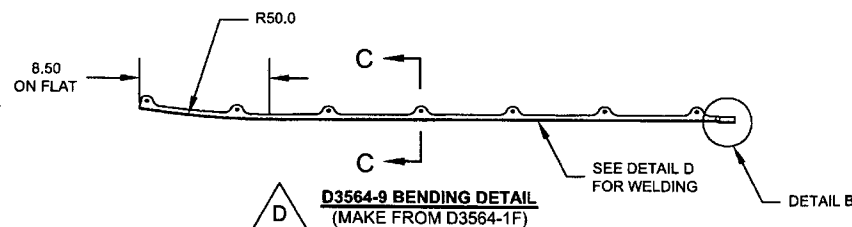
**NOTE:** Date & initial all entries



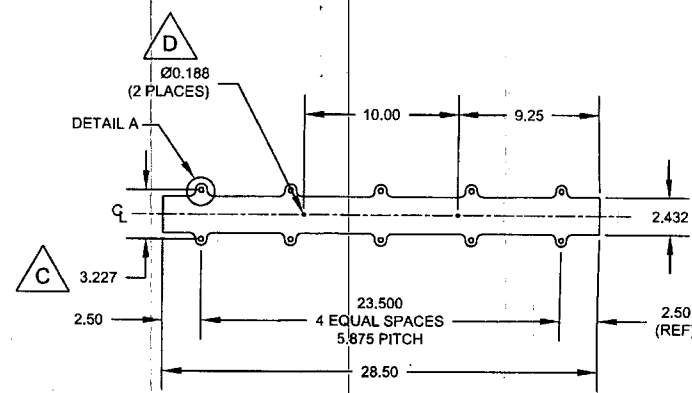
**D3564-5F FLAT PATTERN**



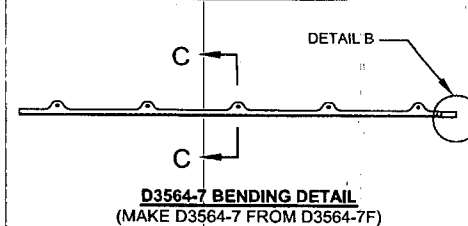
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



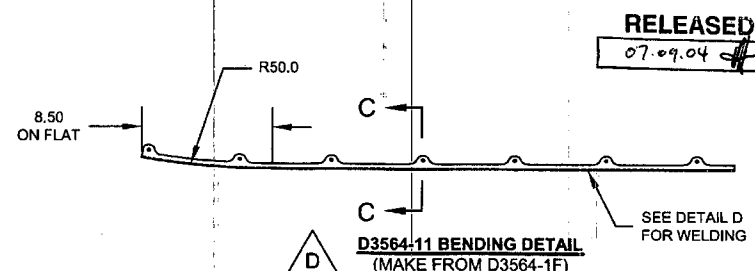
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

RELEASED  
07.09.04

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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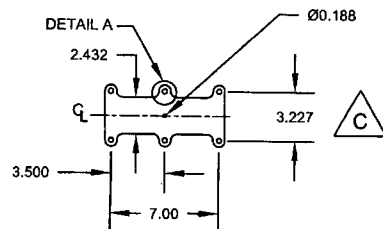
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

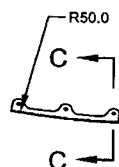
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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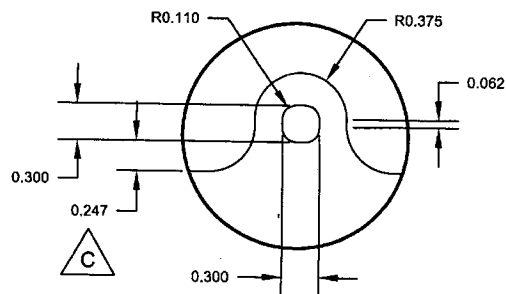
**NOTE:** Date & initial all entries



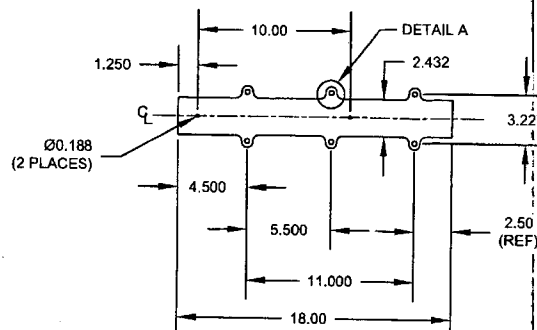
**D3564-13F FLAT PATTERN**



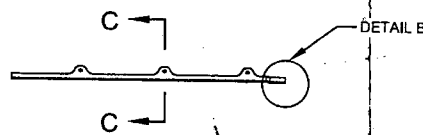
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



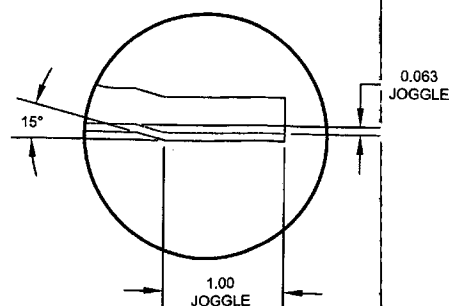
**DETAIL A**  
SCALE 1:1



**D3564-15F FLAT PATTERN**

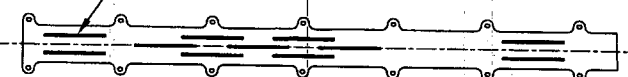


**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



**DETAIL B**  
SCALE 1:1

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH  
(11 PLACES)  
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

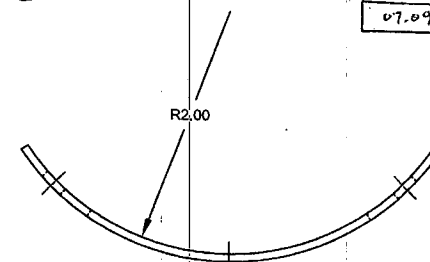


**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)

*also covered*

**RELEASED**

07.09.04



**SECTION C-C**  
SCALE 1:1

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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